

Date: Monday, 15/12/2008 2:01:36 PM  
User: Julie Dawson

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	WEARSHOE
<b>Job Number</b> :	44085		
<b>Estimate Number</b> :	10611		
<b>P.O. Number</b> :		<b>Part Number</b> :	D265611
<b>This Issue</b> :	15/12/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D2656 REV D
<b>First Issue</b> :	/ /	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	35897	<b>Drawing Revision</b> :	D
	<b>Type</b> :	<b>Material</b> :	
	1 : PURCHASED PARTS	<b>Due Date</b> :	22/12/2008
<b>Written By</b> :		<b>Qty:</b>	12
<b>Checked &amp; Approved By</b> :	<u>5008.12.15</u>	<b>Um:</b>	Each
<b>Comment</b> :	Est: D 02.10.24 Re-format KJ est rev E 07.06.06 waterjet EC		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M1010S20GA	1010/1025 SHEET
-----	------------	-----------------



12  
106478 X 5 = 4.25



**Comment:** Qty.: 0.8500 sf(s)/Unit Total: 10.2000 sf(s)  
1010/1025/A21/6aA SHEET

109289 X 8 = 6.8  
109289 X 8 = 12-18

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------

**Comment:** FLOW WATER JET

1-Cut as per Dwg D2656

Dwg Rev: DProg Rev: D

18 8-12-18

2-Deburr if necessary

18 8-12-18

13

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



18 8-12-18

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

508/12/18 (13)

5.0	BRAKE NC	NC BRAKE
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**Comment:** NC BRAKE

1-Form on Brake as per Dwg D2656 using Jigs DT8261 and DT8326

2-Form joggle as per Dwg D2656 using Jig DT8158 Identify as D2656-11

508/12/31 (13)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 44085

Part Number: D265611

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 02/01/05 (X13)

7.0

POWDER COATING

POWDER COATING



m 109648



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

2:35

OVEN TEMPERATURE:

370°

FINISH TIME:

3:05

FL 09/01/05

(13)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



JS



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-01-06

(X13)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FR-20

JS

09-01-06

(X13)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

AD 09/01/07

(13)

Job Completion



MF 09-01-06

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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> <u>H4025</u>
<b>Description:</b> Wearshoe		<b>Part Number:</b> D2656-11
<b>Inspection Dwg:</b> D2656	<b>Rev:</b> D	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
26.650	+/-0.010	26.650	✓			
23.150	+/-0.010	23.150	✓			
21.150	+/-0.010	21.150	✓			
17.650	+/-0.010	17.650	✗			
13.400	+/-0.010	13.400	✗			
9.150	+/-0.010	9.151	✓			
5.650	+/-0.010	5.652	✗			
2.000	+/-0.010	2.000	✗			
1.885	+/-0.010	1.888	✗			
0.300	+/-0.010	.307	✗			
0.300	+/-0.010	.306	✗			

<b>Measured by:</b> <u>VB</u>	<b>Audited by:</b> <u>S</u>	<b>Prototype Approval:</b>	N/A
<b>Date:</b> <u>8-12-18</u>	<b>Date:</b> <u>08/12/18</u>	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	07.06.13	New Issue	KJ/JLM <u>AS</u>	<u>B</u>

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

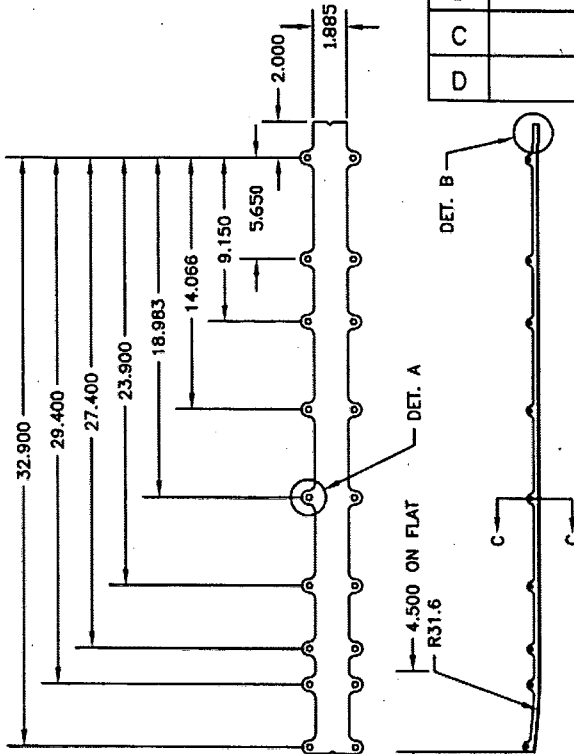
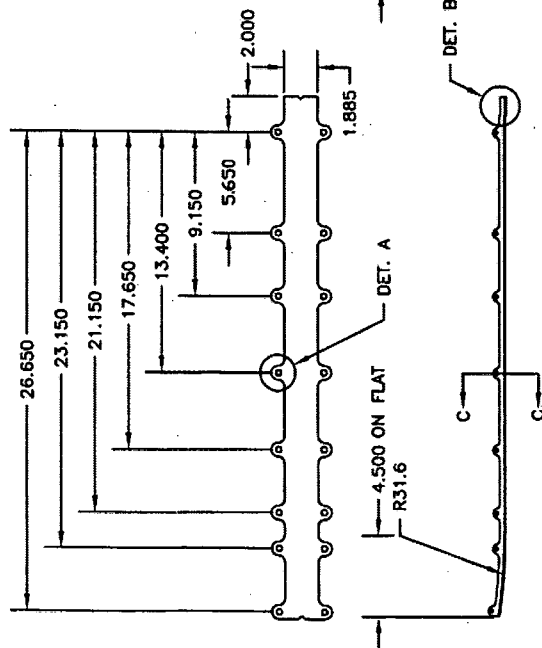
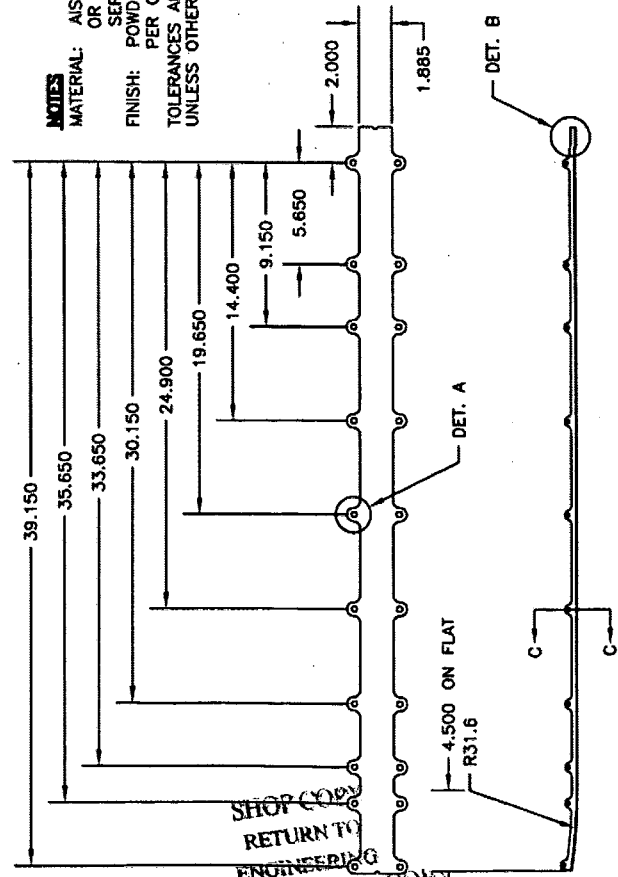
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN DS		DRAWN BY CP		DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]		APPROVED [Signature]		DRAWING NO. D2656	REV. D SHEET 1 OF 4
DATE 05.08.17				TITLE WEARSHOE	SCALE 1:10
A	97:03:25		NEW ISSUE		
B	97:06:02		CHANGED TABS		
C	97:06:26		R31.6 WAS R19.5		
D	05.08.17		ENLARGE ALL HOLES TO IMPROVE FIT		

**D2656-13****D2656-11****D2656-15****NOTES**

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008  
OR CSA G40-21, 38W/44W/50W/60W/70W  
SERIES STEEL, 20 GAUGE (0.040 THICK)  
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6)  
PER QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED

**RELEASED**  
05.09.08

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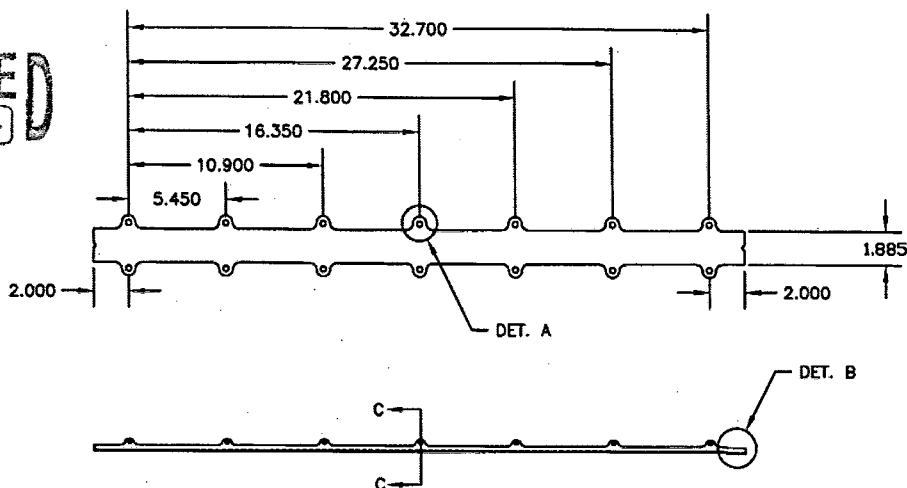
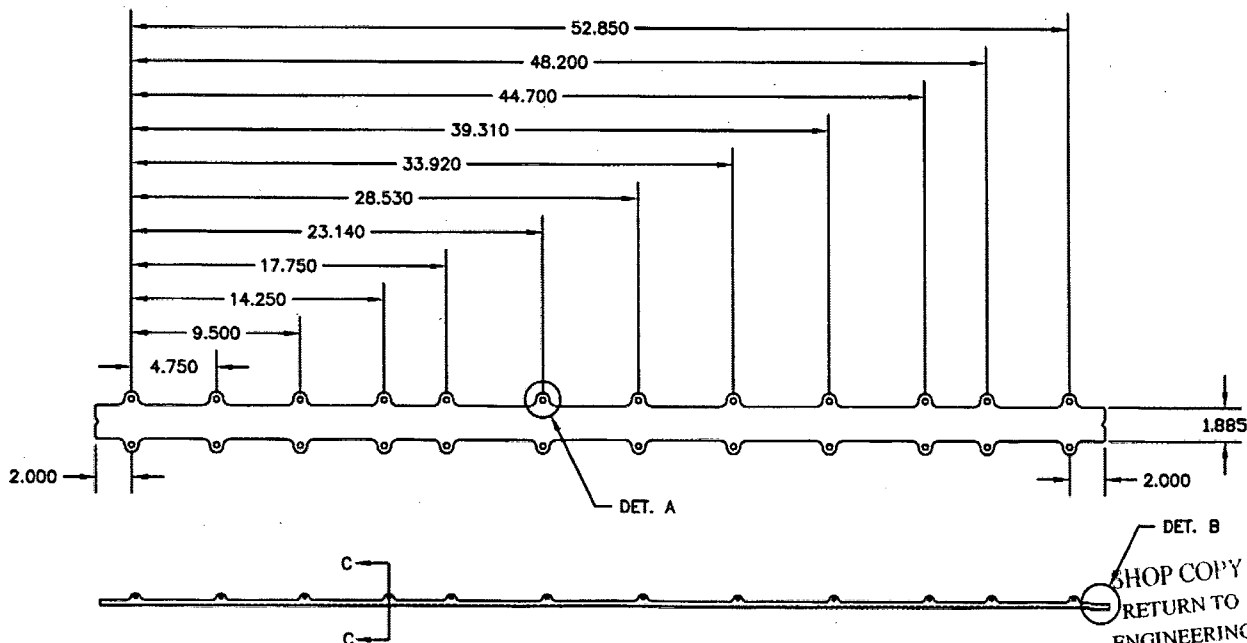
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DATE <b>05.08.17</b>		TITLE <b>WEARSHOE</b>	SCALE 1:10

**RELEASED**  
*05.07.06***D2658-21****D2656-23****NOTES**

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W  
SERIES STEEL, 20 GAUGE (0.040 THICK)  
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018  
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

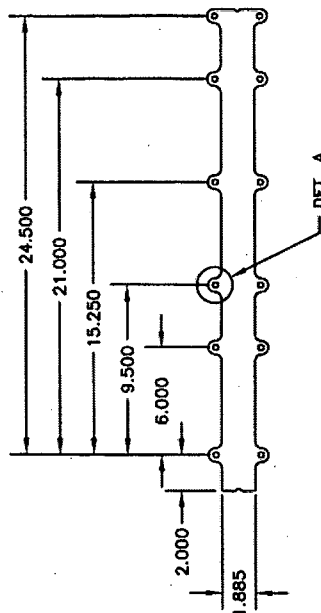
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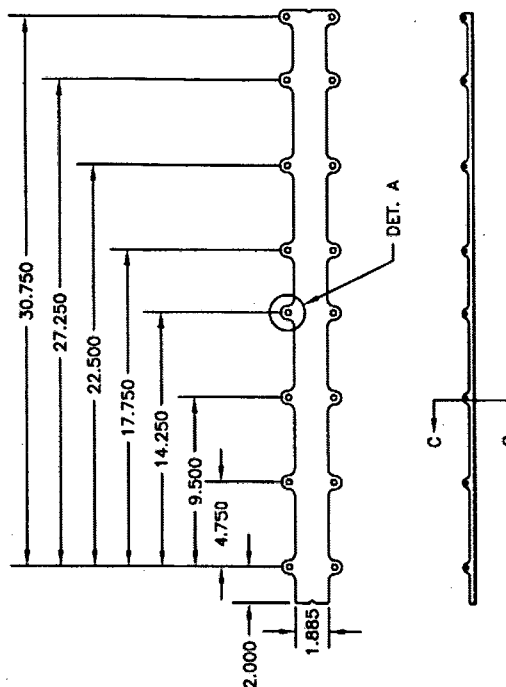


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DATE 05.08.17		TITLE WEARSHOE	SCALE 1:10

D2656-33

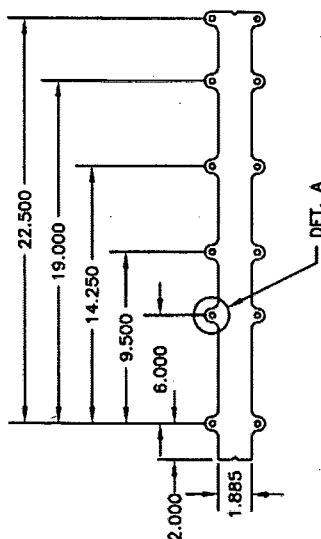


D2656-37

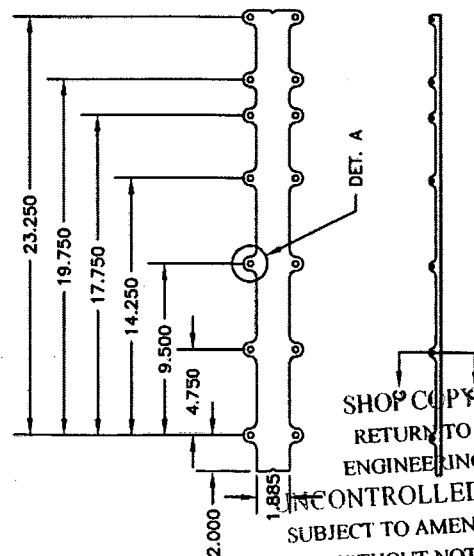


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D2656-31



D2656-35



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NOTES

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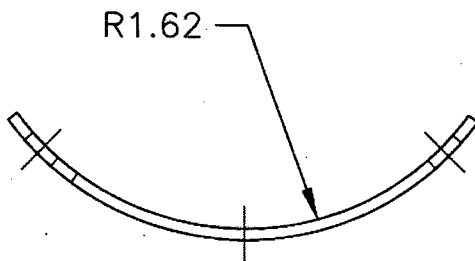
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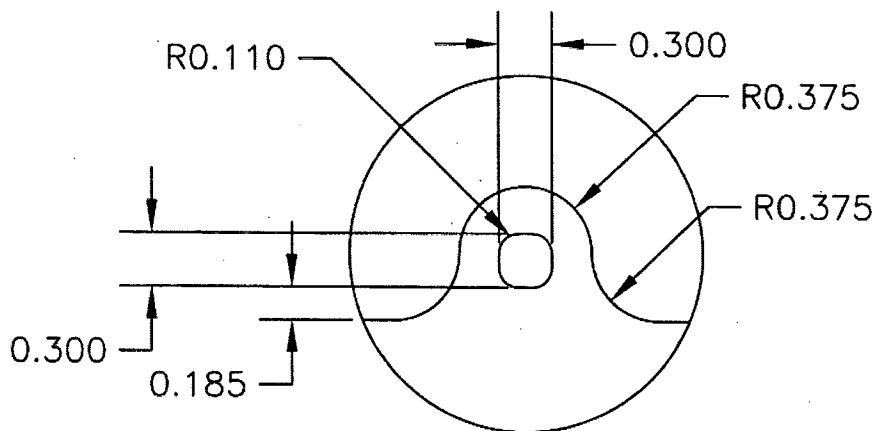
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DATE 05.08.17	TITLE WEARSHOE		SCALE 1:10

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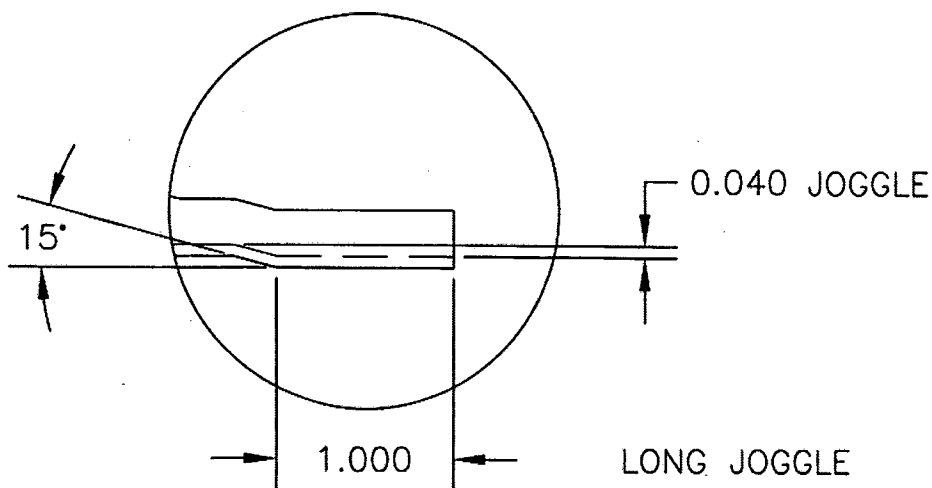


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### DETAIL A



### DETAIL B



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